



Dart Aerospace Ltd.
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K6A 1K7
Canada

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RBT18520-8
Job Sheet 186724



11283
J20

Part No: RBT18520-8

Job Qty: 5 ea

Part Name: Pivot Bar



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520-8 REV:11 IPP REV A 18.02.06 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Machining-4		
120	Lathe Conv	5 pcs	12/7/18	12/7/18	0.25	0.83	Lathe Conv-2		
130	QC	5 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Machining-5		
140	Mill Conv	5 pcs	12/7/18	12/7/18	0.25	0.83	Mill Conv 2		
150	QC	5 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Machining-5		
160	QC	5 pcs	12/7/18	12/7/18	0.00	0.00	QC8 Machining-5		
170	Packaging	5 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2		
180	QC21-SA	5 Ea	12/7/18	12/7/18	0.00	0.00	QC21		

Part Op
Descriptions: 170 - IDENTIFY AND STOCK

21
-80

JAN 10 2019

Job BOM

Part / Item Component Name	Quantity	Operation	Container
7767T61 Low-Carbon Steel Round Tube, 0.188" Wall Thickness, 3/4" OD	2.4650 ft (.493 ea)	90-Start up Operation	5054347

5054345 / 5054344 / 5053007
0.750 0.750 0.958

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	7767T61	2	6	0

Part Specifications

Specifications could not be found.



Container No: S141392



Part: RBT18520-8

Job No: 186724

Serial No/Batch: S141392

Revision: 11

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Plex 11/20/18 1:34 PM Dart.lajeunesse.marie

SCRAP

344 = 0.248 382
345 = 0.2475 383
347 = 0.2475 384
227 = 0

0.743 Total

Date: 01/03/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

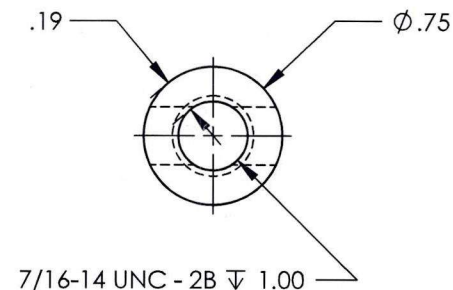
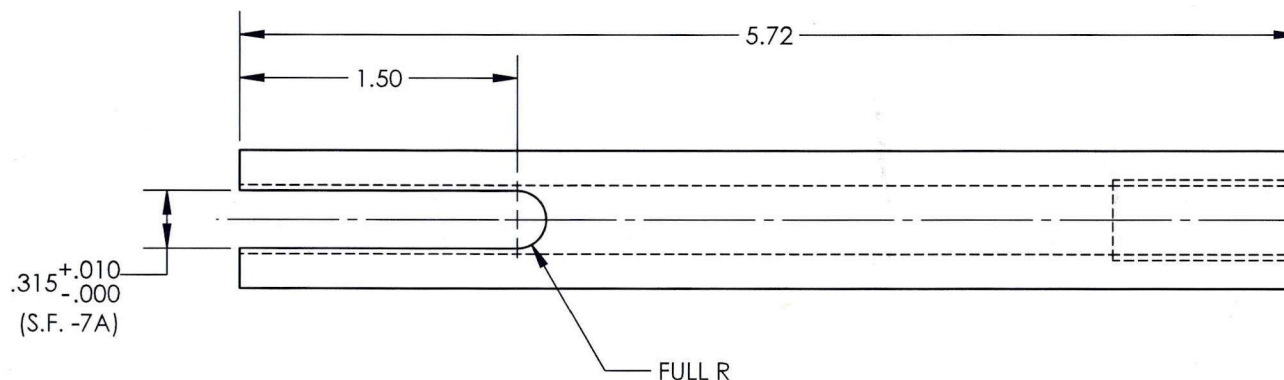
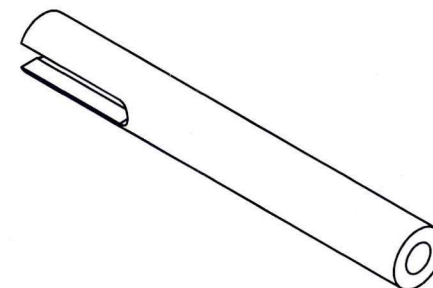
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : 											

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
10	16-0096	-8 ADDED RADIUS TO END OF SLOT. CH'D DIMS WAS .188 WALL IS .19. WAS .315 SLOT S.F. -7A IS .315 +.010 -.000 (S.F. -7A).			8/4/2016	DPD	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186724 MLO

1871-20



(-8)
TUBE

DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-8	REV 11
MAT'L CDS HEAT TREAT FINISH SEE -7 WELDMENT SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE 8/17/2000
SHEET 8 OF 17	